

Date: Tuesday, 02/10/2007 12:53:40 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 34964
 Estimate Number : 12578
 P.O. Number : N/A
 This Issue : 02/10/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A
 Previous Run : 34474
 Written By : Linda Lacelle
 Checked & Approved By :
 Comment : Est Rev. A New Issue 07.05.24 EC

Drawing Name : ARM
 Part Number : D3560041
 Drawing Number : D3560 UNDER REVIEW
 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 09/10/2007 Qty: 5 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 PULL FROM STOCK:		
2.0	D3560041	ARM WELDMENT
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) ARM WELDMENT B332643 = 5 334477 = 5 <i>12 07.10.02</i> 5		
3.0	D35921	PLATE
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) PLATE 334478 = 3 334260 = 2 <i>12 07.10.02</i> 5		
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 1-Weld assembly as per dwg D3560 <i>12 07.10.02</i> 5		
5.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP <i>E1 02/10/03</i> 5		

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Drawing Name: ARM

Job Number: 34964

Part Number: D3560041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10 07-10-03 5

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AM 07-10-03

5 10

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

B

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11 07-10-03

5

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

07-10-03

5

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

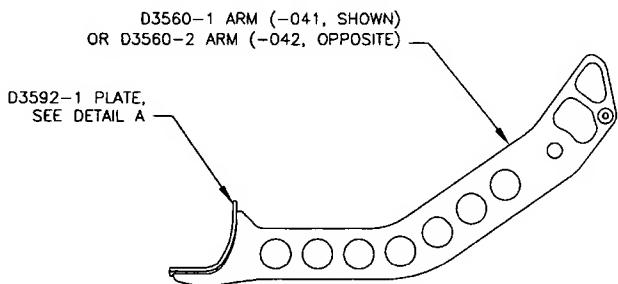
10 07-10-03

5

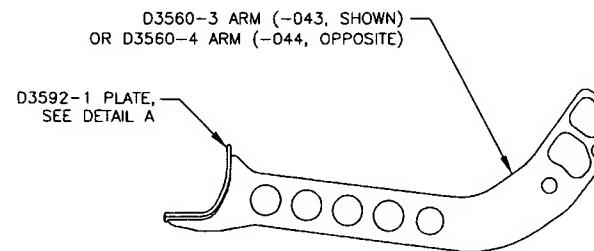
Job Completion



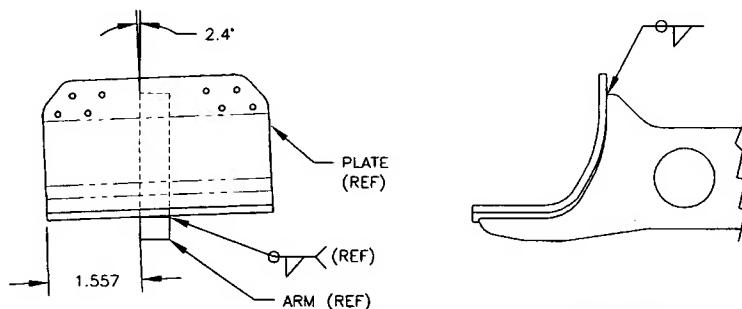
11 07-10-04



D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
07.06.19

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DART AEROSPACE LTD.

DESIGN	07.06.19	REMOVE POWDER COAT
CHECKED	APPROVED	DRAWING NO. D3560
A	06.09.25	NEW ISSUE
99	99	DART
		DART AEROSPACE LTD. MARKSBURY, ONTARIO, CANADA
		REV. C
		SHEET 1 OF 3
		SCALE
		1:4

